

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: 204 SKIDTUBE "I" BEAM
<b>Job Number</b>	: 29675		
<b>Estimate Number</b>	: 10996		
<b>P.O. Number</b>	: N/A	<b>Part Number</b>	: D2597
<b>This Issue</b>	: 11/23/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b>	: D2597 REV D
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b>	: D
<b>Previous Run</b>	: 28802	<b>Material</b>	: N/A
<b>Written By</b>	: _____	<b>Due Date</b>	: 12/5/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: _____		
<b>Comment</b>	: Est: D 98.10.15    Eliminated DEO, Changed Dwg Revision    KS		

Job Number:

1.0	D25003100	Ext'n - 1" Beam Web 4"
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Pick:

Qty	Part Number	Description
1	D2500-3-100	Extrusion

Batch

Batch 13 25751

m. A 06/11/30 (4)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut D2500-3 to length: 84.25"

Use Jig DT8094 to drill pilot holes.

Open to 0.625 diameter using a uni-bit.

m. 2 06/11/30 ④

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Acid Etch and Alodine per QSI 005 4.1

m.h 06/11/30 (4)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/23/2006 11:56:22 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 204 SKIDTUBE "I" BEAM

Job Number: 29675

Part Number: D2597

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

*Pmc 06-11-30 (4)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(4)*

Comment: FINAL INSPECTION/W/O RELEASE

*06/12/01*

Job Completion



*U 06.12.01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

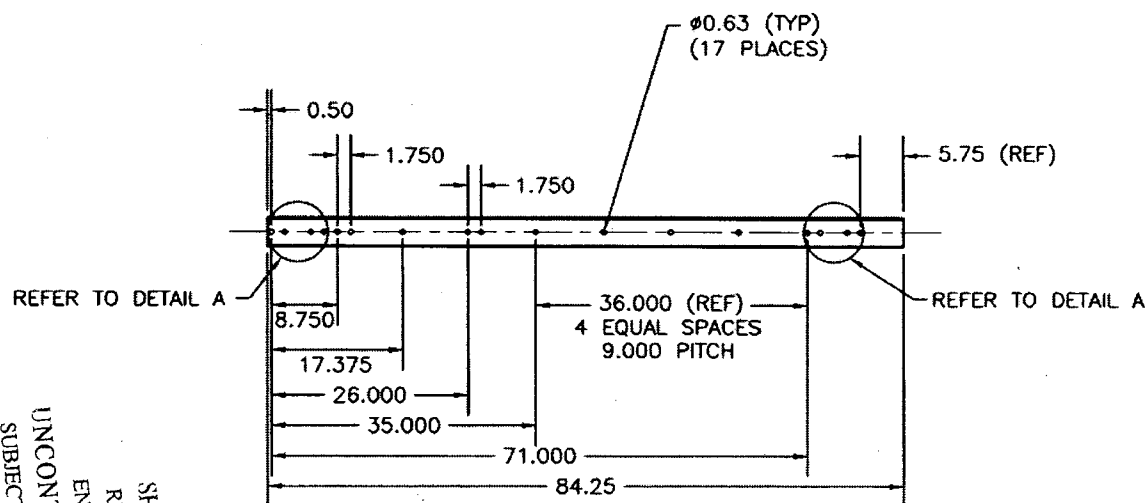
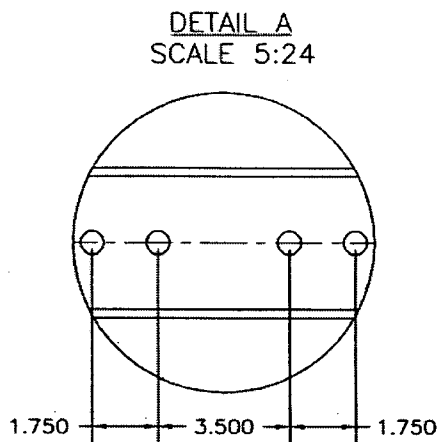
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

QA COPY  
2/11/81

DESIGN	<i>PHF</i>	DRAWN BY	<i>CP</i>	<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>PHF</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2597	SHEET 1 OF 1
DATE				TITLE	SCALE
98.09.14				204 WEB	1:24
A		96.09.16		NEW ISSUE	
B		96.10.29		5.75 WAS 0.50	
C		97.07.23		Ø0.63 WAS Ø0.56	
D		98.09.14		INCORPORATED DEO 9097	

RELEASED  
98.9.17 JS



MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 29675